

Friday, June 17, 2011 7:37:07 AM

Page 1

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Tooling:

Date:

Date:

SPC (Y/N):

Date:[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70903

Friday, June 17, 2011 7:37:07 AM

Page 2

Item ID: D350-689-043

Accept

Revision ID:

Item Name: Dual High Back Seat Assembly

Start Date: 6/16/2011 Start Qty: 1.00

Required Date: 6/23/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

11/11/08

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45pm
320°F
2:15pm

1 of 11/08/09

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1X of 11/08/09

150

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Assemble as per IIN 350-689

25/11/08/10 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70903

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Item ID: D350-689-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Dual High Back Seat Assembly

Start Date: 6/16/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00

Customer:




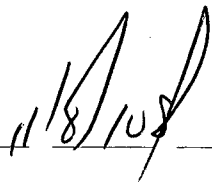

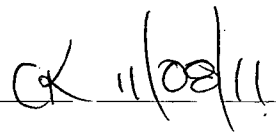
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11-05-10
(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, June 17, 2011 7:37:14 AM

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 6/16/2011**Required Date:** 6/23/2011**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP Rev:A 08-12-24 new issue DD verified by:ECI PP Rev:B as per
DSI 9498 DD 10.02.12 verified by:JLM

[illegible]

70866 x 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 70903

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3021-041 Manufactured No 150 Each 3.0000 1 1
Tube Assembly
71089 x 1
GA 68731 3
3
11-8-3

D3022-1 Manufactured No 150 Each 0.0000 1 1
Seat Pan
70869 x 1
GA 68731 3
3
11-8-3

D3024-1 Manufactured No 150 Each 13.0000 3 3
Spacer
70869 x 1
GA 68731 3
3
11-8-3

D3031-1 Manufactured No 150 Each 19.0000 2 2
Loop
70869 x 1
GA 68731 3
3
11-8-3

D3031-1 Manufactured No 150 Each 19.0000 2 2
Loop
70869 x 1
GA 68731 3
3
11-8-3

D3031-1 Manufactured No 150 Each 19.0000 2 2
Loop
70869 x 1
GA 68731 3
3
11-8-3

D3808-041 Manufactured No 150 Each 0.0000 2 2
Seat Rail Assembly
70869 x 1
GA 68731 3
3
11-8-3

B70906 (1x)
B71146 (1x)

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 70903

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3809-1 Manufactured No

150 Each

5.0000

4



Sliding Block

Location

Loc Qty

Loc Code

ST084

5

70411

5

MS20600-AD4W3

Purchased

No

150

Each

941.0000

6



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

808

111636

118

117505

500

117601

190

WA018

133

107939

133

MS21042L3

Purchased

No

150

Each

2,139.000

17



Nut

Location

Loc Qty

Loc Code

ST300

2139

116391

9

116549

430

117441

800

117601

400

117885

500

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 70903

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

150

Each

5,134.000

6



Nut

Location

Loc Qty

Loc Code

ST300

5134

117441

2840

117601

794

117885

1500

MS24693-S272

Purchased

No

150

Each

107.0000

4



Screw

Location

Loc Qty

Loc Code

ST288

107

116391

11

117677

50

117977

46

MS24694-S148

Purchased

No

150

Each

30.0000

4



Screw

Location

Loc Qty

Loc Code

ST289A

30

108960

30

MS24694-S3

Purchased

No

150

Each

21.0000

8



Screw

Location

Loc Qty

Loc Code

ST289

21

108936

7

112794

4

117977

10

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 70903

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-17 Purchased No

150 Each

122.0000

4

4



Screw

Location

Loc Qty

Loc Code

ST292

122

11540

22

117591

100

MS27039-1-19 Purchased No

150 Each

66.0000

6

6



Screw

Location

Loc Qty

Loc Code

ST292

66

112794

66

MS27039-4-21 Purchased No

150 Each

21.0000

6

6



Screw

Location

Loc Qty

Loc Code

ST292

10

117977

10

ST293

11

114055

1

117771

10

NAS1149D0332J Purchased No

150 Each

2,229.000

17

17



Washer

Location

Loc Qty

Loc Code

ST297

2000

117087

2000

ST298

229

105793

12

117291

217

M118078

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 70903

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0432J

Purchased

No

150

Each

212.0000

6

6



WASHER



EP 11/08/10

Location

Loc Qty

Loc Code

ST298

212

114718

18

116583

194

6

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

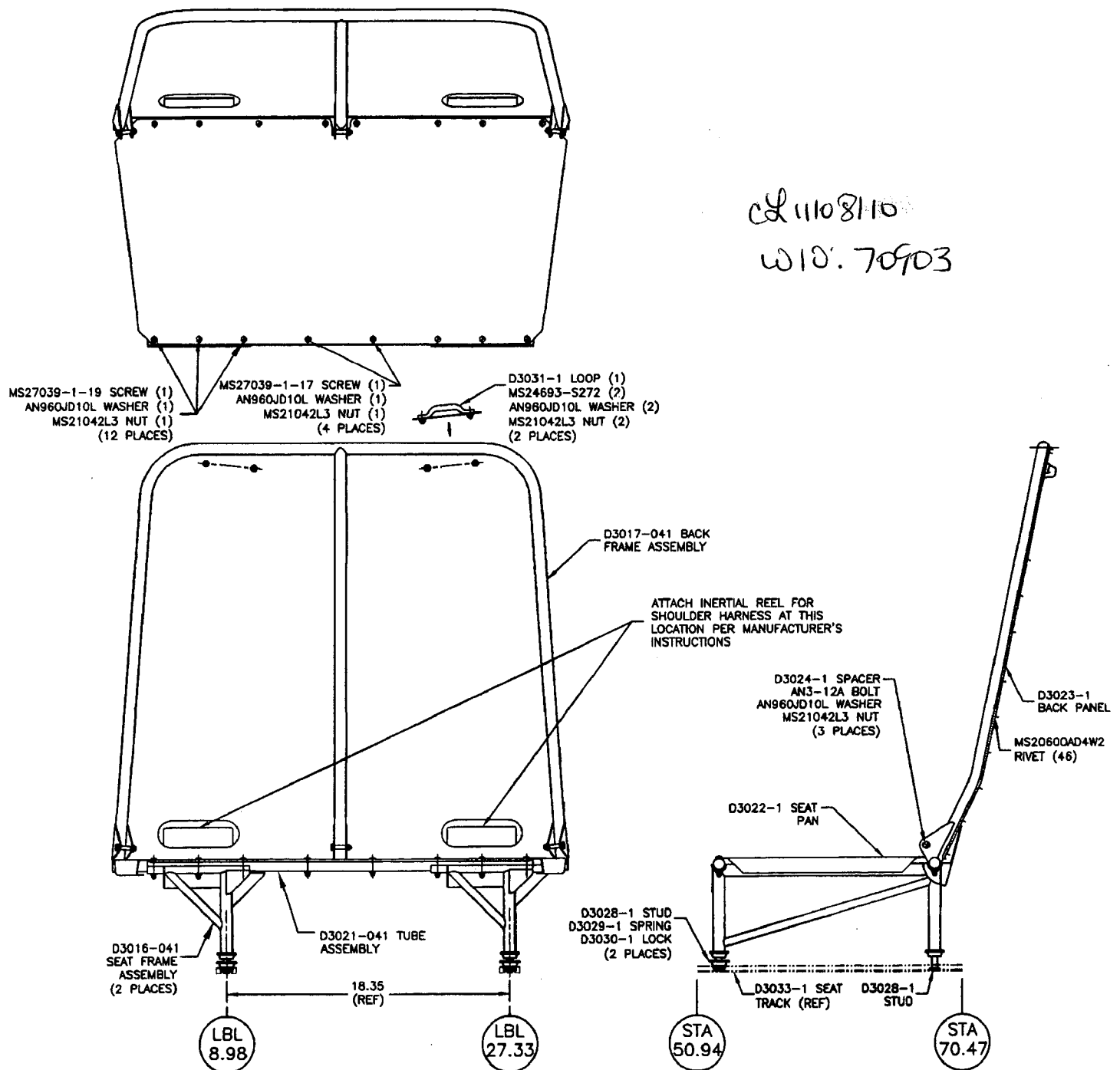


FIGURE 25-5: Installation of D350-689-041 Dual High Back Seat Assembly

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25-00-00

25.5 WEIGHT AND BALANCE

The following weight and balance information is for the Dart Dual High Back Seat Installation. The weight and balance of the parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011	27.0 lb	-18.2 in	-491 in-lb	60.7 in	1639 in-lb
Dual High Back Seat Installation	12.2 kg	-0.46 m	-5.6 m-kg	1.54 m	18.8 m-kg
D350-689-013	2.0 lb	-18.2 in	-36 in-lb	60.7 in	121 in-lb
Floor Provisions Kit	0.9 kg	-0.46 m	-0.4 m-kg	1.54 m	1.4 m-kg

25.6 PARTS LIST

Qty		Part Number	Description
X		D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X	D350-689-013	FLOOR PROVISIONS KIT
1	X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
	2	D3016-041	SEAT FRAME ASSEMBLY
	1	D3017-041	BACK FRAME ASSEMBLY
1		D3018-1	SEAT CUSHION
1		D3019-1	BACK CUSHION
	1	D3021-041	TUBE ASSEMBLY
	1	D3022-1	SEAT PAN
	1	D3023-1	BACK PANEL
	3	D3024-1	SPACER
1		D3025-1	BEAM
1		D3026-1	CHANNEL
1		D3027-1	CLIP
1		D3027-3	CLIP
1		D3027-5	CLIP
4		D3027-7	CLIP
	4	D3028-1	STUD
	2	D3029-1	SPRING
	2	D3030-1	LOCK
	2	D3031-1	LOOP
1		D3032-1	SPACER
1		D3033-1	SEAT TRACK
1		D3033-3	SEAT TRACK
6	23	AN960JD10L	WASHER
	3	AN3-12A	BOLT
16		MS20426AD3-6	RIVET
17		MS20426AD4-6	RIVET
18		MS20470AD4-5	RIVET
2		MS20470AD4-6	RIVET
30		MS20470AD5-6	RIVET
	46	MS20600AD4W2	RIVET
8		MS21059L3	NUTPLATE
6		MS27039-1-10	SCREW
	4	MS27039-1-17	SCREW
	12	MS27039-1-19	SCREW
	4	MS24693-S272	SCREW
2		MS24693-S273	SCREW
	23	MS21042L3	NUT (OR MS21042-3)

CL11108110

WID: 70703

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